

Date: Wednesday, 5/16/2007 8:14:43 AM
 User: Kim Johnston

Process Sheet

Split-1

23

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32384
 Estimate Number : 10836
 P.O. Number : N/A
 This Issue : 5/16/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A
 Previous Run : 31252
 Written By :
 Checked & Approved By :
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW
 Part Number : D29391
 Drawing Number : D2939 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 6/6/2007
 Qty: 4 Um: Each

Type : MACHINED PARTS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101001

7075-T7351 2X6X6 25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: 331356

SA 07.06.26

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly. J.F.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

SA 07.06.26

3.0

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 07.06.26

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 07.06.26

Header:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW

Job Number: 32384

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description:

50

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/06/27

(7)

60

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m.k 07/06/27

70

SPRAY PAINTING

SPRAY PAINTING



210.4058 07/06/27 (2)

Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

80

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

207.07.03 (2)

90

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

2 7/7/4 (2)

100

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/04

Job Completion



U 07-07-04

DART AEROSPACE LTD	Work Order: 32384
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125	.126	.127		
B	0.100	0.140		.125	.127	.127	.126		
C	0.100	0.140		.125	.128	.127	.127		
D	0.210	0.230		.225	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.251	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.501	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.239	.240	.239		
N	0.100	0.140		.120	.119	.119	.119		
O	0.540	0.560		.550	.546	.550	.550		
P	0.490	0.510		.498	.498	.499	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.751	2.751	2.750	2.751		
S	0.240	0.270		.254	.254	.254	.254		
T	0.100	0.180		.137	.137	.137	.137		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.363		
W	0.316	0.321		.318	.318	.318	.318		
X	1.250	1.270		1.260	1.259	1.260	1.259		
Y	1.565	1.585	DT8695 A/B	1.575	1.574	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: J.F.
Date: 01.06.25	Date: 07/06/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	